

Friday, September 30, 2016 9:01:54 AM

Page 1

NS1

Stop ***NS2***

Customer:

NR1

Stop *NR2*

Date:

Insp. Stamp

A

Quality Control

TR 16/10/03

24

24

PR Keholo3

24

DAS
38

9446 839 7420

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design ☐	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data ☐	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling ☐	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre ☐	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material ☐	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport ☐	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge ☐	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA ☐	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation ☐	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date ☐	☐	Manufacturing Process	☐	OTHER : _____			
Misidentified ☐	☐	Past Due	☐				

Work Order ID 151586

Friday, September 30, 2016 9:01:54 AM

151586

Page 2

Item ID: D5348-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Doubler

Start Date: 9/30/2016 Start Qty: 24.00

24

Cust Item ID:

Required Date: 10/14/2016 Req'd Qty: 24.00

24

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

Identify as per dwg & Stock Location: ST163

0.00

140

Packaging

Memo

0.04

conty 24OCT 04 2016DAS
6
9-89

Packaging

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.40

DAS
21
9-89OCT 05 2016

Quality Control

VS 16/10/05DAS
21
9-89OCT 05 2016

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WORK ORDER NON-CONFORMANCE / UPDATE



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OTHER : _____																																																																																																																															

Picklist Print

Friday, September 30, 2016 9:01:59 AM

Page 1

Work Order ID: 151586

151586

Parent Item: D5348-1

D5348-1

Parent Item Name: Doubler

Start Date: 9/30/2016

Required Date: 10/14/2016

Start Qty: 24.00

Required Qty: 24.00

Comments: IPP REV:A 15.12.08 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M301S22GA		Purchased		No			sf	7.2000		2.455579			

M301S22GA

301 SS Sheet - Full hard McMaster p/n: 3543T77

PR 10/10/03

Location

Loc Qty

Loc Code

MAT020

7.2

M132831

1.2

M135692

6

3

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Substation ☐	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date ☐	☐	Manufacturing Process	☐	OTHER :			
Misidentified ☐	☐	Past Due	☐				

DQA: _____ Date: _____



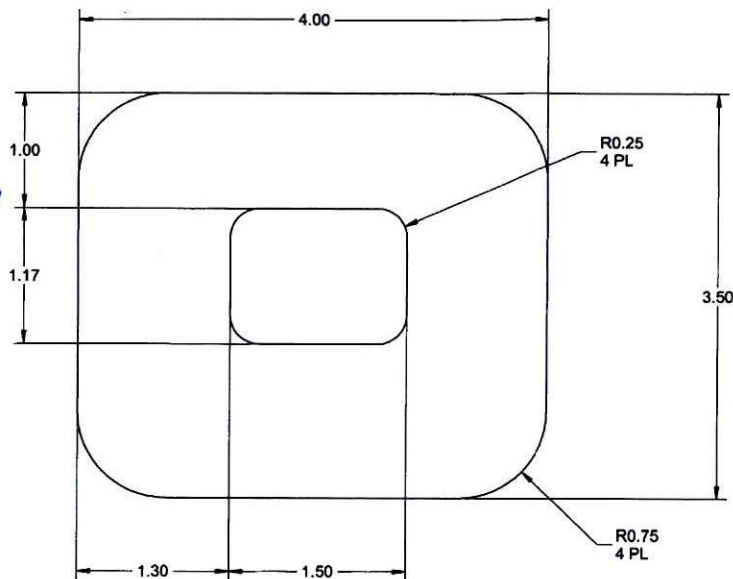
WORK ORDER NON-CONFORMANCE / UPDATE

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		OTHER : ☐							

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 151586 MJS
1609-30



D5348-1 DOUBLER

NOTES:

- 1) MATERIAL: AISI 301 SS SHEET, 0.032" THK
MINIMUM 1/4 HARDNESS (NOT ANNEALED)
2B FINISH
PER AMS 5517
OR AMS 5518
OR AMS 5902
OR AMS 5519
OR ASTM A666 WITH MIN. F_{tu} = 125 ksi & MIN F_{ty} = 75 ksi
REF DART SPEC M301S22GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.6
- 7) WEIGHT: 0.11 lbs

RELEASED
2015-12-07
ECN 15-649

APPROVED

A		NEW ISSUE		VS	15.10.21
REV.	DESCRIPTION	BY	DATE		
DESIGN	VS				
DRAWN	VS				
CHECKED	RF				
MFG. APPR.	JLM				
APPROVED	HS				
DE APPR.	DS				
DATE	15.10.21				

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D5348**
REV. A
SHEET 1 OF 1
TITLE **DOUBLER**
SCALE
NTS

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